

Work Order ID 50196

July 10, 2009 11:23:21 AM



Page 1

Item ID: D2989-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989 2- tack weld mesh on basket as per dwg D2989 using DT9445 jig 3- remove from jig and weld table plate as per dwg D2989 A/R ER3

D 09.07.20

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

C 09.07.21

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 5 or 6/21



(SL) 0





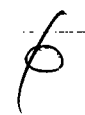


Work Order ID 50196

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Page 2

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Basket Lid Assembly					
Start Date:	7/15/09	Start Qty:	1.00		Cust Item ID:	
Required Date:	7/27/09	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss (Ref:4.3.5.2) per QSI005 4.3-Steel <i>PRESS WASH</i> Memo 1- Plug holes prior to Powdercoat! 13-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4:1 Spray Paint Black: <i>11:00</i> <input type="checkbox"/> Wing Walk: <i>11:30</i> <input type="checkbox"/> IST COAT: <input type="checkbox"/> START TIME: <i>11:45</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>400°</i> <input type="checkbox"/> <i>SECOND COAT START 11:45</i> <i>09-07-22 EL</i>	0.00 <i>0.00 9-7-22</i>							<i>BR 09-07-22</i> 
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 <i>0.00</i>							<i>2) S orlosky</i>  
150  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 <i>0.00</i>							<i>09/07/28</i>  <i>mf 09-07-27</i>

W/O: 50196		WORK ORDER CHANGES					
DATE	STEP	Perment change PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/7/23	# 100	ADD step to wing work for Day. *	bf	09/07/23	1		S 07/7/23
			AA	09/07/28			

Part No: D2989-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

July 10, 2009 11:23:21 AM

Work Order ID: 50196

Parent Item: D2989-041RevD

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 7/15/09


Required Date: 7/27/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2506RevF		Manufactured	No			100	Each	5.0000	1.0000			
												
Label Plate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
44275	1	
48607	4	

D2512-7RevE		Manufactured	No			100	Each	9.0000	1.0000			
												
Rib												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9	
43987	1	
44865	1	
48326	3	
48666	4	

D2581RevA1		Manufactured	No			100	Each	33.0000	2.0000			
												
Mounting Bracket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	33	
46086	2	
48428	31	

AD 09.07.20

PD 09.07.17

2 PD 09.07.20

Picklist Print

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Work Order ID: 50196



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 7/15/09

Required Date: 7/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2989-13RevD		Manufactured	No			100	Each	6.0000	2.0000			
Rib												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 6

48327 2

48452 4

12221-1 09/07/17

~~D2989-17RevD~~ Manufactured No



Rib

48318 → 1

48427 → 2

D2989-19RevD Manufactured No



Rib

100 Each 0.0000 2.0000

100 Each 7.0000 2.0000

2 PD 09.07.17

3 PD 09.07.20

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 7

44867 1

47976 2

48102 4

2 PD 09.07.17

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Shop Packet Print

Picklist Print

July 10, 2009 11:23:21 AM

Work Order ID: 50196

Parent Item: D2989-041RevD

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 7/15/09

Required Date: 7/27/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3832-3RevA

Manufactured

No

100

Each

6.0000

1.0000



Mesh (Lid)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

47747

3

48608

3

1 PD 09-07-20

D3833-3RevA

Manufactured

No

100

Each

13.0000

2.0000



Mesh (Lid End)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

46308

13

2 PD 09-07-20

D3836-041RevA

Manufactured

No

100

Each

3.0000

1.0000



Rib Assembly (Basket Lid, LH)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

48099

1

48440

2

1 PD 09-07-17

July 10, 2009 11:23:21 AM

Shop Packet Print

Picklist Print

July 10, 2009 11:23:21 AM

Work Order ID: 50196



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 7/15/09

Required Date: 7/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3836-042RevA

Manufactured

No

100

Each

3.0000

1.0000



Rib Assembly (Basket Lid, RH)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

46089

1

48441

2

1 PD 09.07.17

D3852-041RevA

Manufactured

No

100

Each

3.0000

1.0000



Rib Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

48098

3

1 PD 09.07.17

D3852-042RevA

Manufactured

No

100

Each

3.0000

1.0000



Rib Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

48097

3

1 PD 09.07.17

July 10, 2009 11:23:21 AM

Shop Packet Print

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

w/o 50196

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (2N D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	<i>[Signature]</i>	DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE BASKET LID ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.24		

8

7

6

5

4

3

2

1

D

C

B

A

D

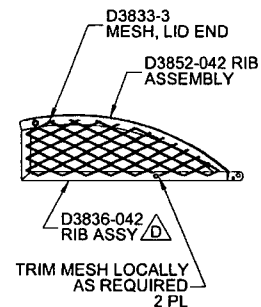
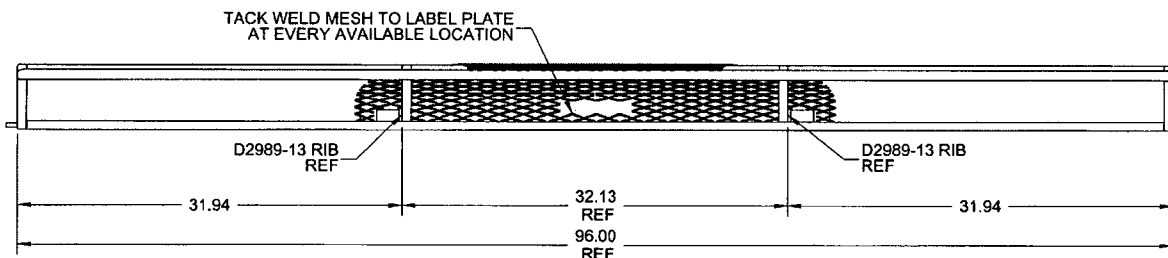
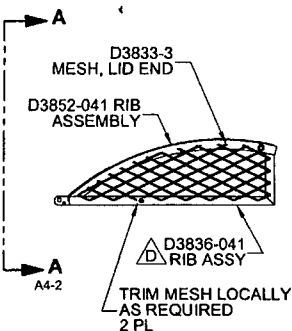
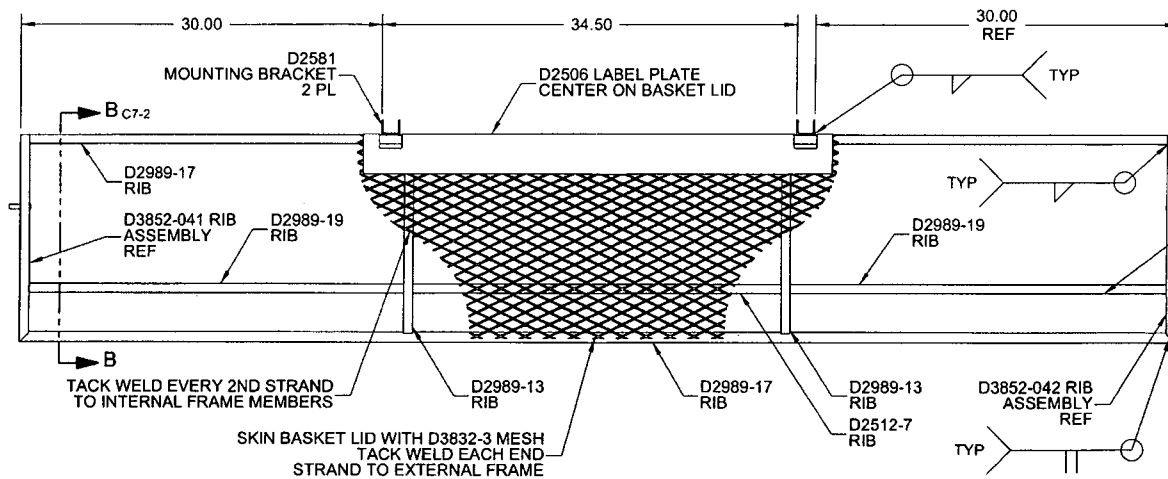
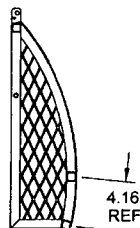
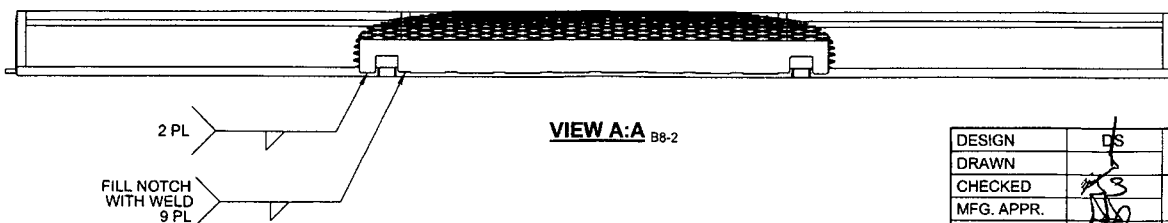
C

B

A

SECTION B-B

D7-2

**D2989-041 BASKET LID ASSEMBLY**
(MESH SHOWN LOCALLY FOR CLARITY)**VIEW A:A**

B8-2

DESIGN	DS
DRAWN	DS
CHECKED	DS
MFG. APPR.	DS
APPROVED	DS
DE APPR.	DS
DATE	08.09.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADADRAWING NO.
D2989

REV. D

SHEET 2 OF 5

TITLE
BASKET LID ASSEMBLY

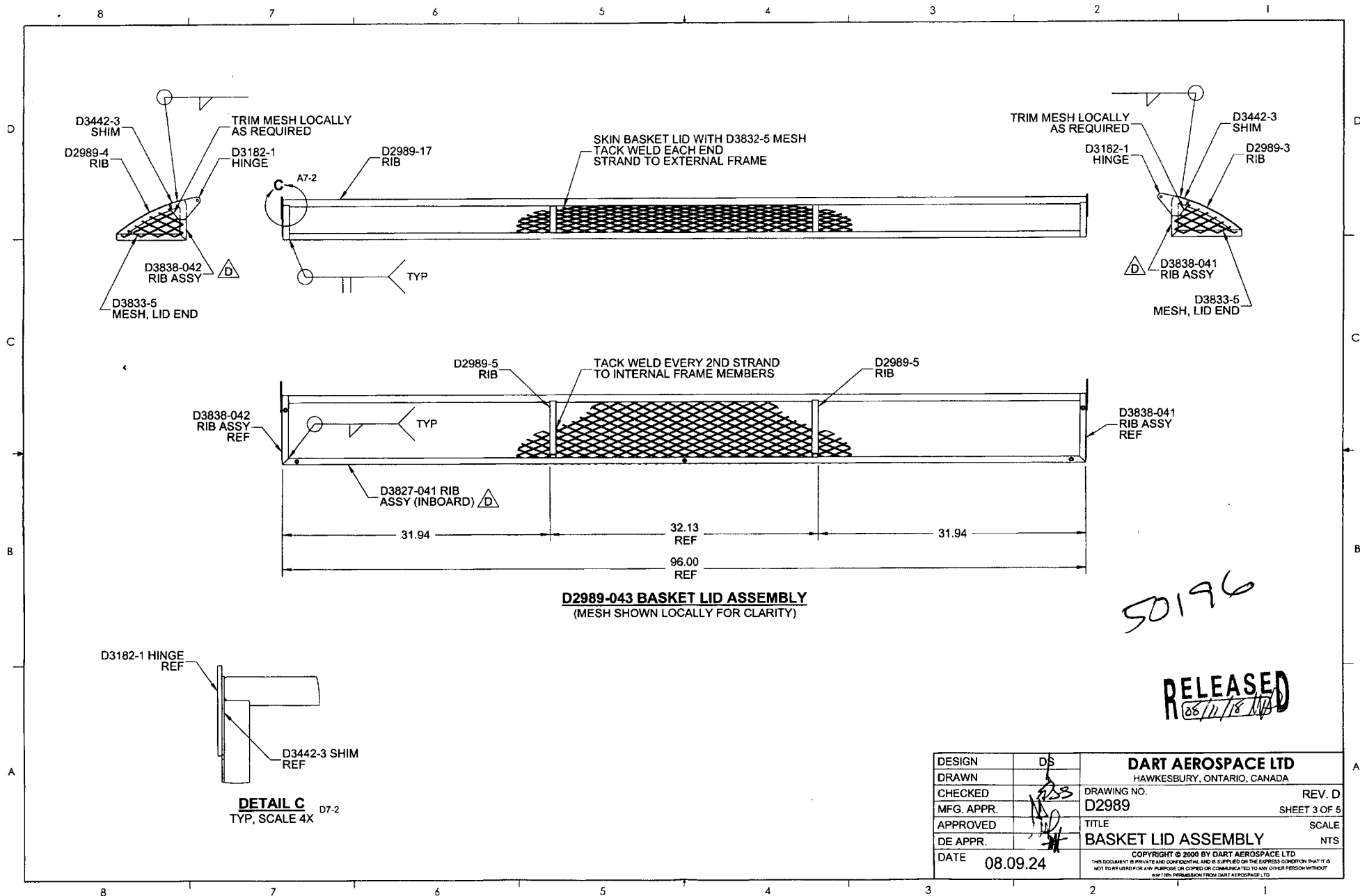
SCALE

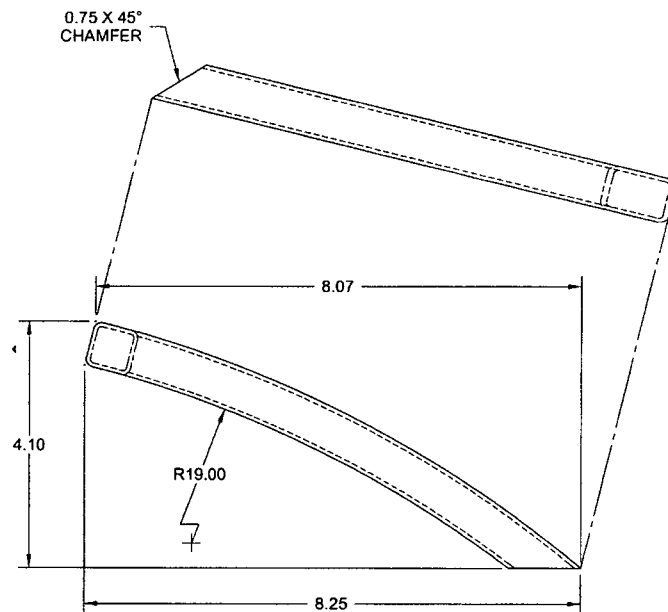
NTS

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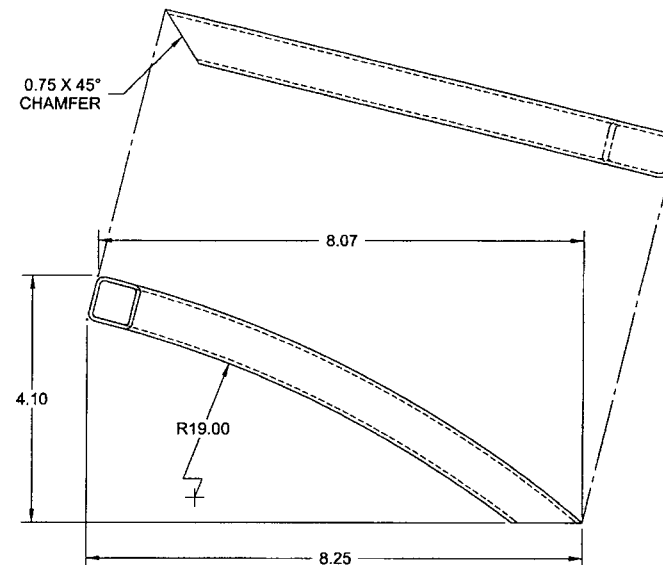
50196

RELEASED
08/11/18/19





D2989-3 RIB

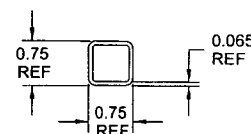


D2989-4 RIB

50196

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



**TYPICAL SECTION
VIEW**

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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